

Work Order ID 127596

December-17-14 1:39:38 PM

127596

Page 1

Item ID: D2855-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cap

Start Date: 12/17/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 12.00

15

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 14-12-23

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2855

Rev B

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 27002

Cast per Dwg D2855

Material Release Note Required

CL 15/01/12 50

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

50x 8015-02-11

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

50

DAS
38
9-89

FEB 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127596

December-17-14 1:39:38 PM

127596

Page 2

Item ID: D2855-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap
 Start Date: 12/17/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00				50X	DAS 28 9.89	FEB 12 2015	
	1- Drill as per Dwg D2855 using DT8235					47	7		J.C.L. 12/03/16
	2- Open holes to 19/64"								
	3- Cut to length as per dwg								
	4- Deburr								
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00				(50)			DAS 38 9.89
150 *150* Powdercoat	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum	0.00							
Powder Coating	Memo	0.00				50	10-2-26	2348	
	START TIME: 9:25								
	OVEN TEMPERATURE: 320°								
	FINISH TIME: 9:55								

FEB 17 2015

P40

DQA:

Date: 15/07/16



QA Closed:

Date: 15/05/20

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>127 596</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>02855-3</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-4987</u>		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15/3/16	B0	③	Dim 0.400 is $\approx$ 0.353. f.c. parts were put in incorrectly in chuck	DAS 12 989 15/3/16	SCRAP - no replace x③	J.C.-L 10/03/15	PD 15-03-16	PD 15-03-16
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☒ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

182/M 15/05/20



Non-Conformance Report

Reviewed			
DQA:			
Date:		Printed on: Monday, March 09, 2015	
Details			
Raised Date 3/9/2015	Status Open	Owner Smith, Patrick	Number NCR15-4607
Target Date 3/24/2015	Standard	Severity MAJOR	
Process Employee finding		Audit	
Raised By Person Downing, Eric M	Raised Against (Department or Supplier) Manufacturing	Fault Category General Lack of attention to work order	
Details found only after powder coating that the D2855-3 caps were not as per drawing. the caps D2855-3 B127596 were not cut to length as per drawing. also the parts were not inspected correctly			
Keywords		Product D2855-3	
Document		Root Cause Lack of Attention	
Closed By	Closed Date	Resolution	

Corrective Action			
Target Date 3/23/2015	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Lacelle, Linda	3/13/2015	3/9/2015
planning to decide to stock D2855-3 caps as D2855 non cut to length caps		D2855-3 caps are needed so parts must be reworked as per drawing	
2	Downing, Eric M	3/20/2015	
retrain inspectors and shop employees to review drawings attached to the work orders more carefully and record on trier job training log		ncr15-4607 recorded on job training logs	
3	Boucher, Sylvie	3/13/2015	
rework parts as per drawing and touch up cut edge with imron paint as per QSI005		J.C.L 15/03/16	

ERIC SAID
IT WAS COMPLETE

Verification & Review			
Target Date 3/23/2015	Owner Smith, Patrick	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	

Work Order ID 127596

December-17-14 1:39:38 PM

127596

Page 3

Item ID: D2855-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Cap

Stop ***NS2***

Start Date: 12/17/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

X50 ϕ JLL 15/04/22 DAS 15 9:00

170

Small Fab

0.00

170

Small Fab

Memo

0.00

Small Fab

Install Inserts as per Dwg D2855

X50 ϕ JLL 15/04/22

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

50 ϕ 15-5-1 DAS 34 9:00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127596

December-17-14 1:39:38 PM

127596

Page 4

Item ID: D2855-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap
 Start Date: 12/17/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>FR-001</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

x 50 of Ill 15/10/13

ML3 **MAY 04 2015**

RS-5-1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

December-17-14 1:39:37 PM

Page 1

Work Order ID: 127596

127596

Parent Item: D2855-3

D2855-3

Parent Item Name: Cap

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-225	AELS8-1032-225	Purchased	No			170	Each	120.0000	2	24	100		
---------------	----------------	-----------	----	--	--	-----	------	----------	---	----	-----	--	--

AI S7-1032-225

Insert

131657

**

Location

Loc Qty

Loc Code

FG

120

118520

120

D2855P

Purchased

No

110

Each

0.0000

1

12 50

D2855P

Cap

**

50x 5p 15-02-11

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

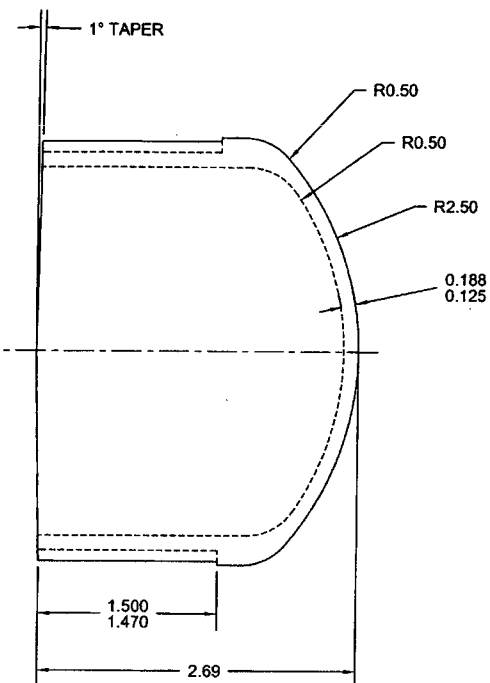
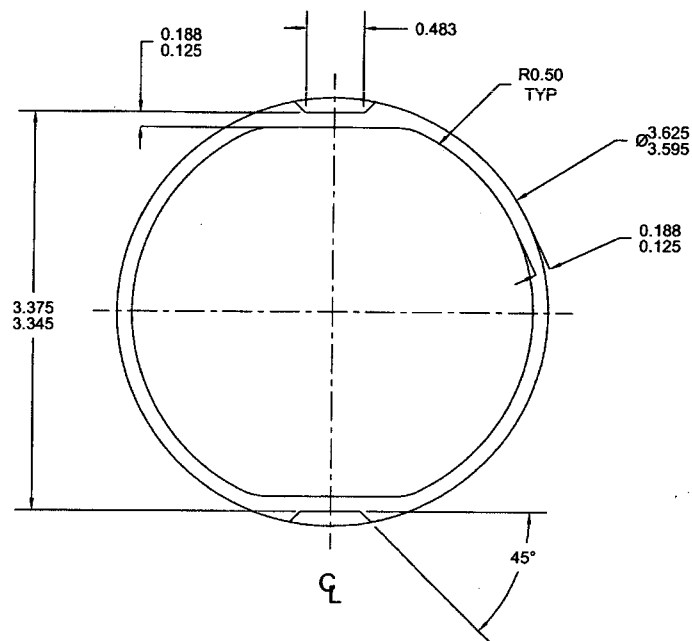
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
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☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other



FOR COPY
RETURN TO
ENTERING
CONTROLLED COPY
AMENDMENT
NOTICE
ORDER
127596-ML5
14-12-23

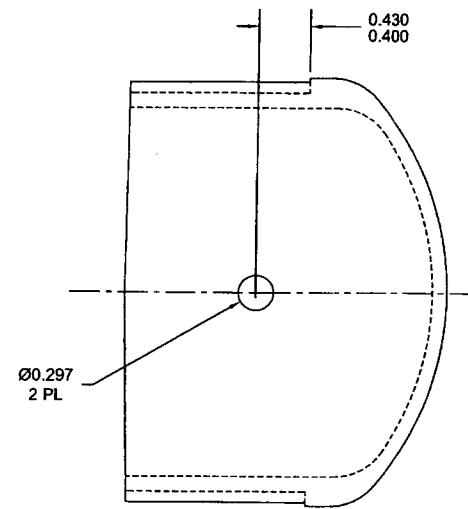
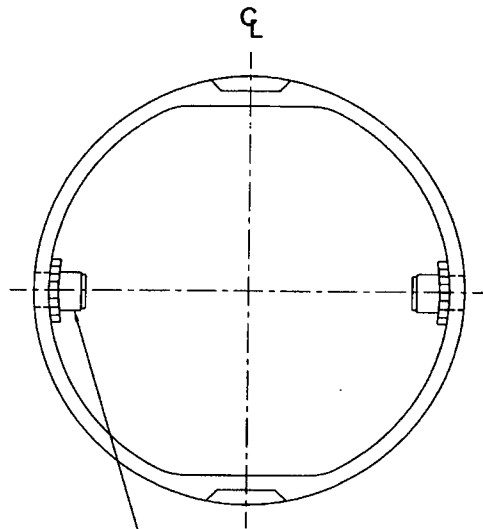
D2855C CASTING DETAIL B

RELEASED
09/07/15 MJD

NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)		RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)		DS	96.12.12
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B SHEET 1 OF 3 SCALE NTS	
DRAWN	RF			
CHECKED	RF			
MFG. APPR.	D2855			
APPROVED	TITLE			
DE APPR.	CAP	DATE 09.06.30		
COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

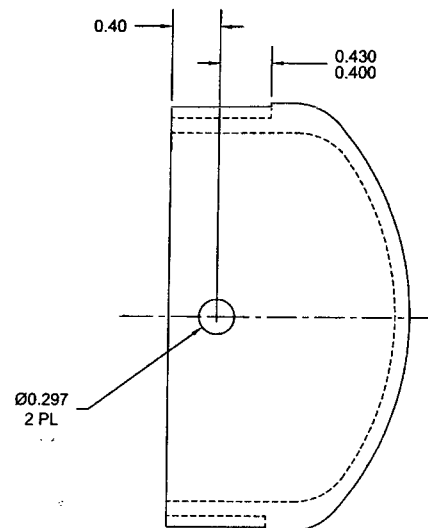
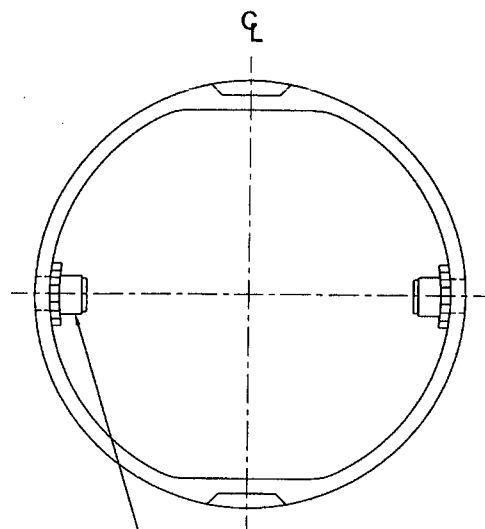
D2855 CAP
(MAKE FROM D2855C CASTING)

RELEASED
21/5/15

NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: PODER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	EP	D2855	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	#	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP
(MAKE FROM D2855C CASTING)

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

RELEASED
2011/11/10

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 3 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO27002

Purchase Order Date 1/12/2015

PO Print Date 1/12/2015

Page Number 1 of 2

Order From :

METALLURGIE SYCA
500 PRINCIPALE

ST.DOMINIQUE, QUEBEC JOH 1LO

VC-MSY01

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450-261-0853

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2855P AS PER DWG D2855 REV. B B127359	Cap	1/30/2015 Yes 1/30/2015		50.00 Each	\$12.50	\$625.00
Line Total:							\$625.00
2	D2855P AS PER DWG D2855 REV. B B127596	Cap	1/30/2015 Yes 1/30/2015		50.00 Each	\$12.50	\$625.00
Line Total:							\$625.00
3	D2965P AS PER DWG D2965 REV. B B127852	Cap	1/30/2015 Yes 1/30/2015		100.00 Each	\$12.50	\$1,250.00

PO Instructions: Fedex Acc#151793240

Note:

1/12/2015

MÉTALLURGIE SYCAING
500 RUE PRINCIPALE
ST-DOMINIQUE, QUÉBEC
J0H 1L0

N° D'ENR. DE TAXE
TAX REG. NO.

N° DE COMMANDE
ORDER NO.

PO 27002

DATE 10-02-2015

VENDU A
SOLD TO

DART AEROSPACE LTD.

ADRESSE
ADDRESS

1270, ABERDEEN STREET

EXPÉDIÉ A
SHIP TO

HAWKSBURY, ONT.

ADRESSE
ADDRESS

KGA-1K7

DATE D'EXPÉDITION
SHIPPING DATE

VIA

CONDITIONS
TERMS

ACHETEUR
BUYER

VENDUEUR
SALESPERSON

100

✓ D-2855

1BTE X 60 pcs X 32 Lbs

1BTE X 40 pcs X 22 Lbs

TRANSPORT: FEDEX

THANKS FOR YOUR SUPPORT

Merci De Vous Encourager

TOTAL

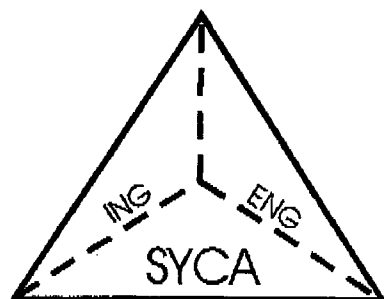
551552

Blueline DCB27

SIGNATURE

FORMULAIRE DE VENTE - SALES ORDER

©Blueline® 2010

**MÉTALLURGIE SYCA Inc.**

500, Principale
St-Dominique, Québec
J0H 1L0

Tél: (450) 261-0853

Fax: (450) 261-0894

E-mail: syca@qc.aira.com

W W W . S Y C A - I N C . C O M

CERTIFICATE OF COMPLIANCE

COMPANY: DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKSBURY, ONTARIO
K6A 1K7

DATE: 2015-FEB-12

SHIPPING MEMO: 551552

TRANSPORT: VIA FEDEX COLLECT

NUMBER OF PAGES: 2

DESCRIPTION	QUANTITY	PART CODE	P.O NUMBER
CAP D-2855	100	D-2855	27002

All item specify in this compliance certificate are manufactured in Canada.

-PRODUCTION LOT: KJJ21022015

-ALLOY: A-356

-NORME: ASTM B-85

-CHEMICAL ANALYSIS: SUPPLY

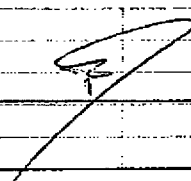
-VISUAL INSPECTION: DONE

-DIMENSIONNAL INSPECTION: NON-APPLICABLE

-SURFACE SMOOTHNESS : ALUMINIUM ASSOCIATION DATA

RESPONSIBLE: CARL JOBIN ING.

SA-101

ROUVILLE STATION INC. 1032, BOUL. RICHELIEU RICHELIEU (QUÉBEC) J3L-0L7 TEL : (450) 658-2183 TEL : (450) 658-2808 FAX : (450) 658-1461										
Coulée # 115 SR										
ELEMENT:	SI	FE	CU	MG	MN	NI	TI	ZN	CR	SR
ALLIAGE (356.1)	6.5 - 7.5	.50	.10	.30 - .45	.05	*	.20	.05	*	*
A356.0		.20	.20	.25 - .45	.10		.20	.10		.007
ANALYSE MOYENNE:	7.03	.22	.04	.44	.01	.006	.11	.04	.005	.003
CHEF DE LABORATOIRE:					Date : 01-07-2014					